

Work Order ID 58743

Tuesday, May 18, 2010 10:07:50 AM



Page 1

Item ID: D4035-041

Accept



Setup Start



Revision ID:

Item Name: Lid Rib Assembly, Fwd (350 Basket)

Stop



Start Date: 5/18/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 5/25/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-5-18 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4035

A

100

Weld per dwg A/R S.S. rod Batch: M113328 0.00



Large Fab

Memo

0.00

Large Fab

- 1- Cut D4035-1 as per dwg D4035
- 2- Drill as per dwg D4035 using DT9562
- 3- remove identification marks and deburr
- 4- Weld bushing in rib as per dwg D4035

SAD 10-05-20

② 10/05/20 ②

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

② 10.05.20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S 10/05/20

Memo

0.00

⑦

130



Packaging

Packaging

Identify as per dwg & Stock Location: uro

0.00

SAD

10-05-20

Memo

0.00

②

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/05/25

MF 10-5-22

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, May 18, 2010 10:07:54 AM

Page 1

Work Order ID: 58743

Parent Item: D4035-041

Parent Item Name: Lid Rib Assembly, Fwd (350 Basket)

Start Date: 5/18/2010

Required Date: 5/25/2010

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------



Spacer Bushing

Manufactured

No

100

Each

1.0000

1



B58406 ① 10/05/20

M304TS0.750W.049

Purchased

No

57790

100

f

380.4845

1.75

①



304 SQ Tube .75x.75x.049W



SAP 10-05-20

Location

Loc Qty

Loc Code

WA

1

57790

1

Location

Loc Qty

Loc Code

MAT

247.7189789

113763

0

114323

46.0489789

114677

201.67

MAT017

132.7655368

113763

24.25

114298

108.515537

1.75 x 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

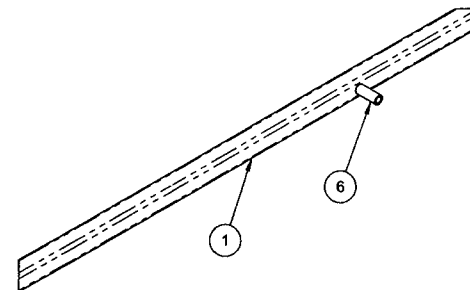
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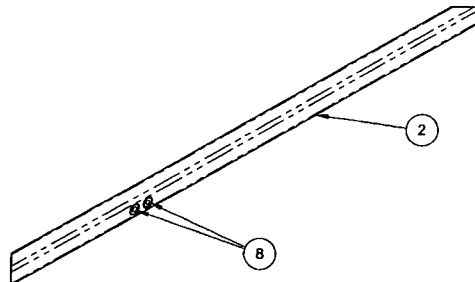
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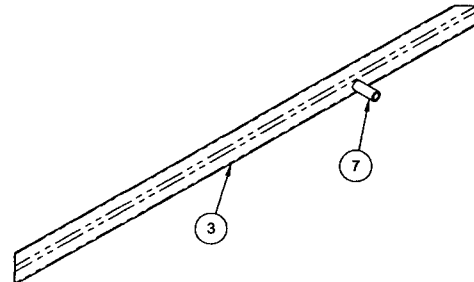
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING



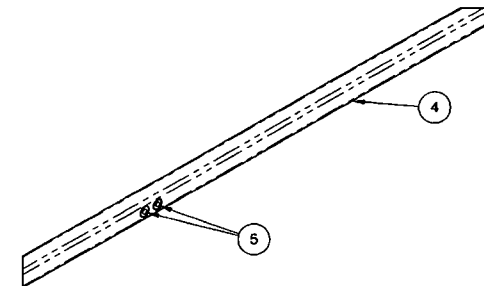
D4035-041 BASKET LID RIB ASSY, FWD



D4035-043 BASKET LID RIB ASSY, AFT



D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)



D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

RELEASED
2010-03-12

58743

A NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION		BY DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID RIB ASSY	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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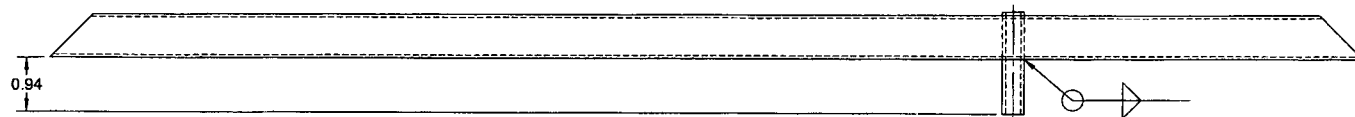
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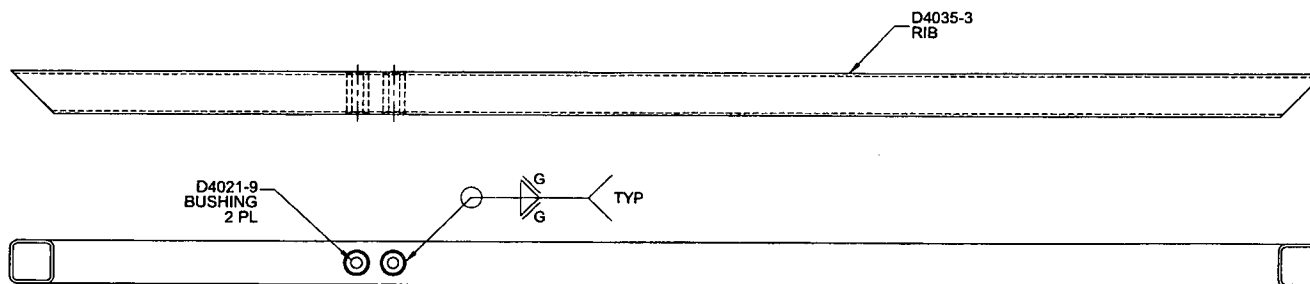
NOTE: Date & initial all entries



D4035-1
RIB

D2327-3
SPACER BUSHING

D4035-041 BASKET LID RIB ASSY. FWD



D4021-9
BUSHING
2 PL

D4035-3
RIB




TYP

D4035-043 BASKET LID RIB ASSY. AFT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.83 lbs
- 8) WELDING: PER DART QSI 004

RELEASED
2010-03-12

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 2 OF 5
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8 7 6 5 4 3 2 1

D4035-5
RIB

D2953-175
SPACER

0.94

D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)

D4035-7
RIB

D4035-11
BUSHING
2 PL

TYP

D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

RELEASED
2010-03-12

58743

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs
- 8) WELDING: PER DART QSI 004

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 3 OF 5
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8 7 6 5 4 3 2 1

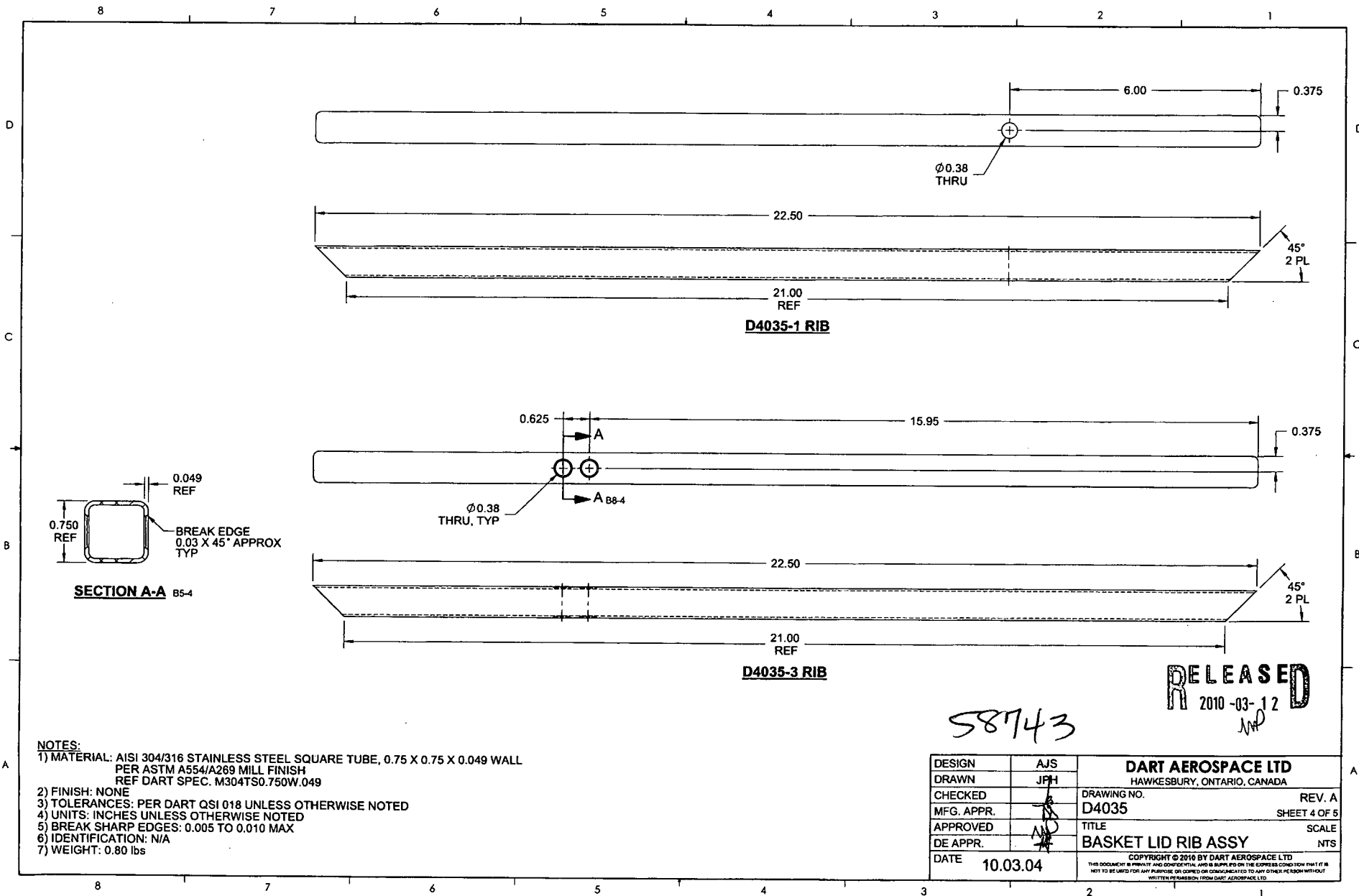
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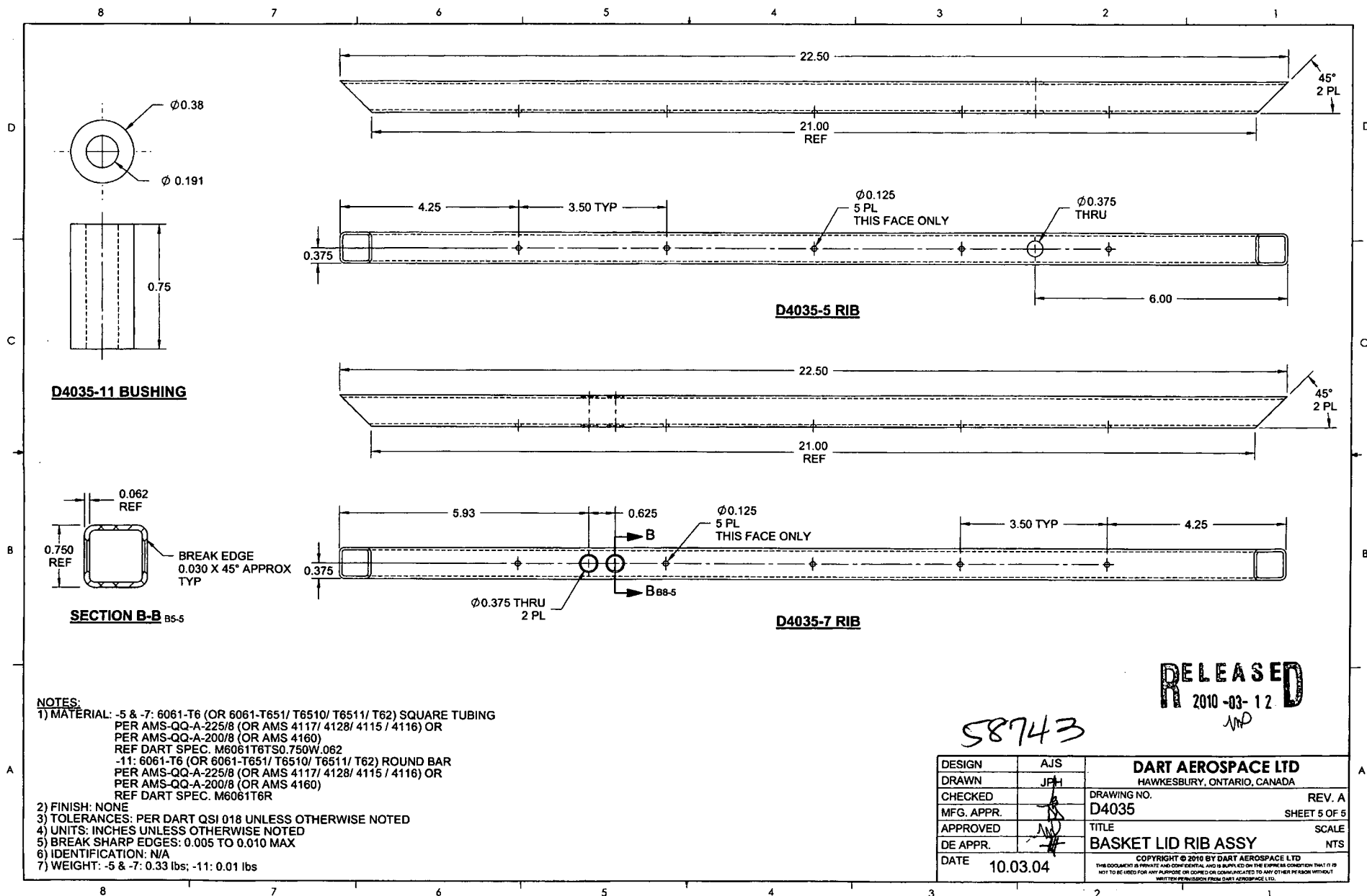
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